

Work Order ID 86610

Friday, July 06, 2012 10:12:13 AM

86610

Page 1

Item ID: D4578-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Latch Weldment Stud

Start Date: 7/5/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ME Date: 12-07-06 Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4578	A
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100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

1-TURN AS PER FOLIO FB088 & DWG D4578

FOLIO REV: NADWG REV: A

2-DEBURR AS REQUIRED

SA 12/7/13

2

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

SA 12/7/13

2

160

QC8- Inspect parts - second check

0.00

160

QC

Memo

0.00

Quality Control

QC 12-67-13 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4578-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Latch Weldment Stud

Start Date: 7/5/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: Wd 0.00***170***

Packaging

Memo

0.00

Packaging

2x

SP
12-7-16

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/18
MS 12/07/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 86610

Parent Item: D4578-1

Parent Item Name: Latch Weldment Stud

Start Date: 7/5/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 12-01-10 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	57.0920	0.083333	0.1754379			
304 ROUND BAR 0.375													

Location

Loc Qty

Loc Code

MAT029

57.092

119346

1.564

120204

2.721

121380

4.807

121728

48

8/12/13

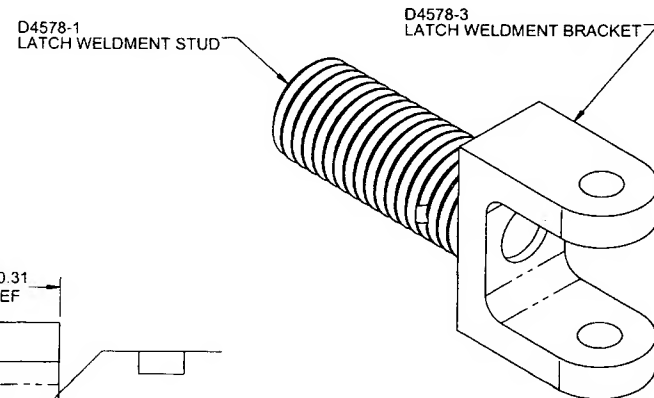
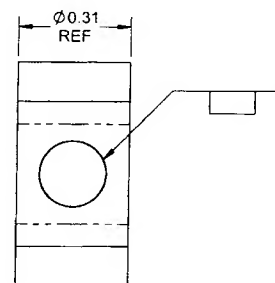
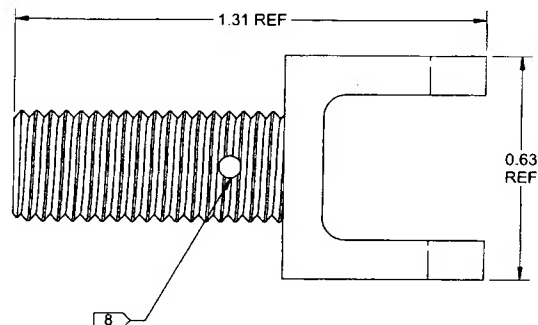
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NOTE: Date & initial all entries



D4578-041 LATCH WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.03 lbs
- 8) ORIENT HOLE IN THREADED STUD AS SHOWN
- 9) WELD PER DART QSI 004

A		NEW ISSUE		RP	12.02.24
REV.		DESCRIPTION		BY	DATE
DESIGN		RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN		RP			
CHECKED		A.P.	DRAWING NO.	REV. A	
MFG. APPR.		[Signature]	D4578	SHEET 1 OF 3	
APPROVED			TITLE	SCALE	
DE APPR.		[Signature]	LATCH WELDMENT	NTS	
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RELEASED
2012-03-08

#86610

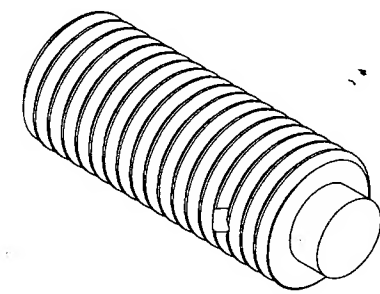
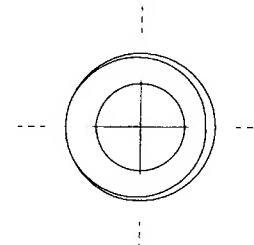
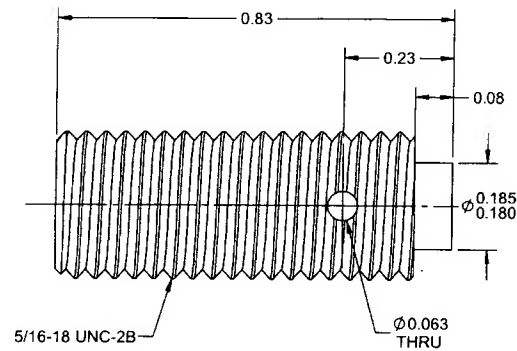
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4578-1 LATCH WELDMENT STUD

#86810

RELEASED
2012-03-08

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.02 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4578	SHEET 2 OF 3
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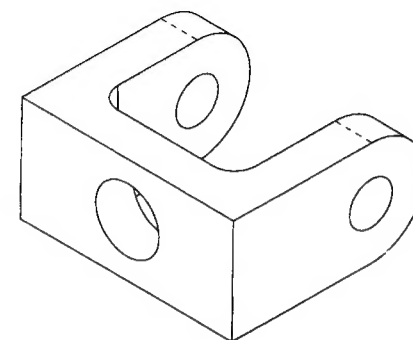
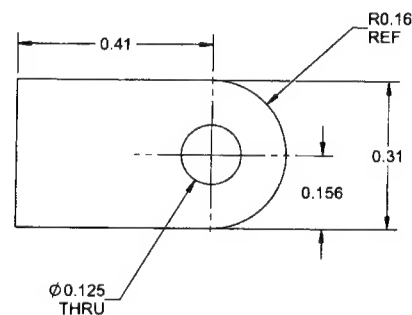
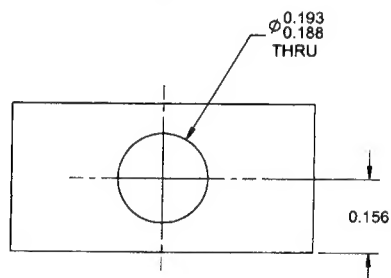
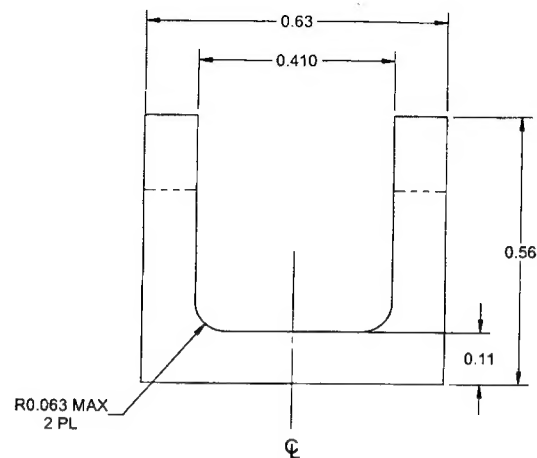
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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


#86610

D4578-3 LATCH WELDMENT BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 PLATE
PER ASTM A276 OR ASTM A240
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
- 7) WEIGHT: 0.01 lbs

RELEASED
R 2012-03-08
JND

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.		D4578	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LATCH WELDMENT	NTS
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